

Work Order ID 81201

81201

Page 1

March-12-12 8:44:54 AM

Item ID: D4035-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lid Rib Assembly, Aft (350 Basket)
 Start Date: 09/03/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 19/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/12 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4035	A								

100 Weld per dwg A/R S.S. rod Batch: 4115778 0.00

100

Large Fab

Large Fab

Memo

0.00

- 1- Cut D4035-3 as per dwg D4035
- 2- Drill holes using DT9563 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

Ac

12.03.15

(x6)

12.03.16 6x

110

110

QC

Quality Control

QC10- Inspect visual per QS1004- ground welds 0.00

Memo

0.00

5.2/03.16

(x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81201

March-12-12 8:44:55 AM

81201

Page 2

Item ID: D4035-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 09/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

8-263/16

(26)

Quality Control

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Basket cell

Memo

0.00

Packaging

12-03-16 (6x)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/3/19

mf-
12-03-16

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Picklist Print

March-12-12 8:44:58 AM

Page 1

Work Order ID: 81201

81201

Parent Item: D4035-043

D4035-043

Parent Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 09/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP revA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4021-9		Manufactured	No			100	Each	50.0000	2	2			
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✓ *D4021-9*
Bushing

**

12.03.15

Location	Loc Qty	Loc Code
WA005	50	
66437	2	
70333	4	
72482	4	
74966	40	

M304TS0.750W.049

Purchased

No

100

f

443.0184

1.75

1.842105

✓ *M304TS0 750W 049*
304 SQ Tube .75x.75x.049W

**

12.03.15

Location	Loc Qty	Loc Code
MAT018	418.2411429	
117775	93.6739	
118472	47.1990839	
118880	0.2736	
119147	76.4906	
119643	39.6981	
120494	160.905859	
MAT034	1.8507	
117337	1.8507	
WA035	22.92654	
118184	22.92654	

1.842105 11.04

W/O:		WORK ORDER CHANGES					
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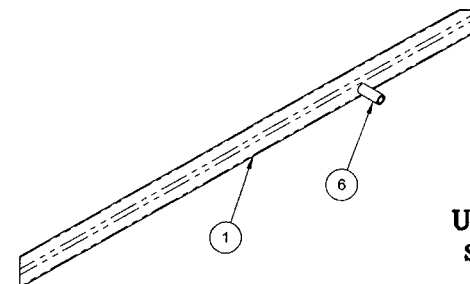
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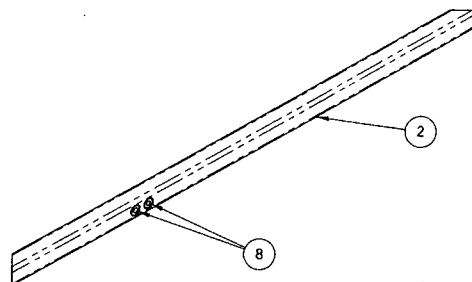
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



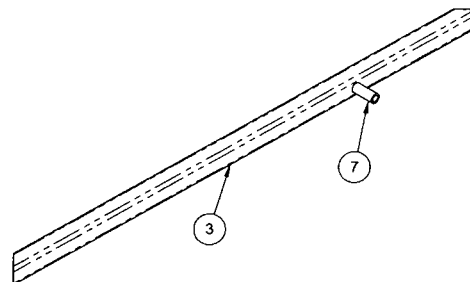
D4035-041 BASKET LID RIB ASSY, FWD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

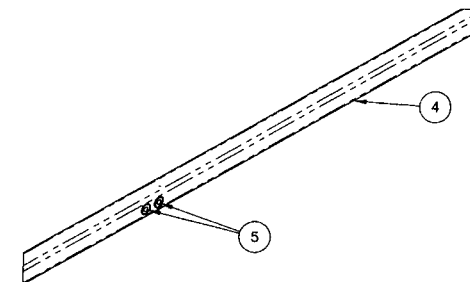
NO. 81201 MCT
12/03/12



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
R 2010-03-12
AM

A NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	[Signature]	DRAWING NO.	REV. A
MFG. APPR.	[Signature]	D4035	SHEET 1 OF 5
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	BASKET LID RIB ASSY	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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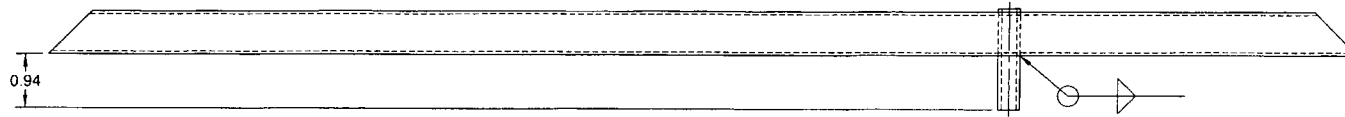
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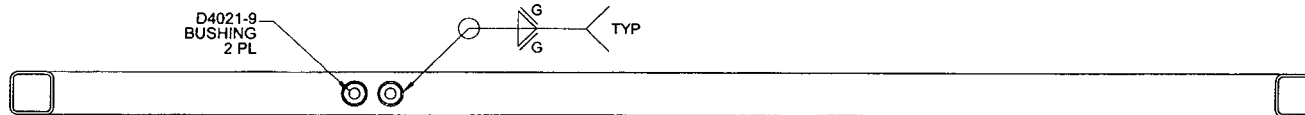
D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD



D4035-3
RIB



D4021-9
BUSHING
2 PL



TYP

D4035-043 BASKET LID RIB ASSY, AFT

RELEASED
2010-03-12
JWD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
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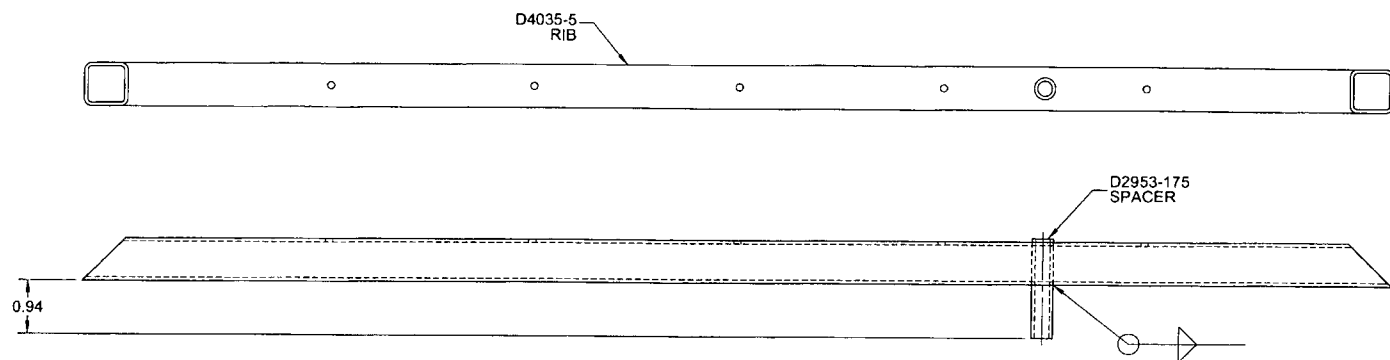
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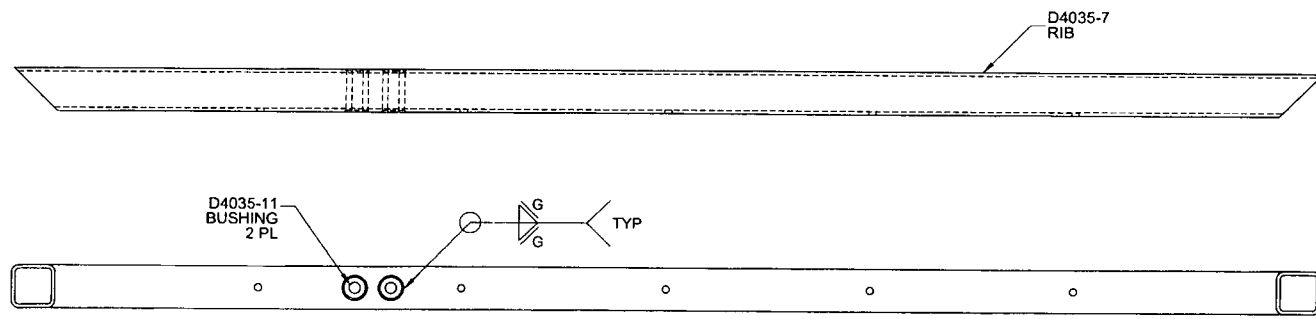
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NOTE: Date & initial all entries

81201



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
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MFG. APPR.		D4035	SHEET 3 OF 5
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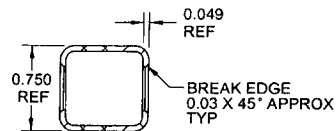
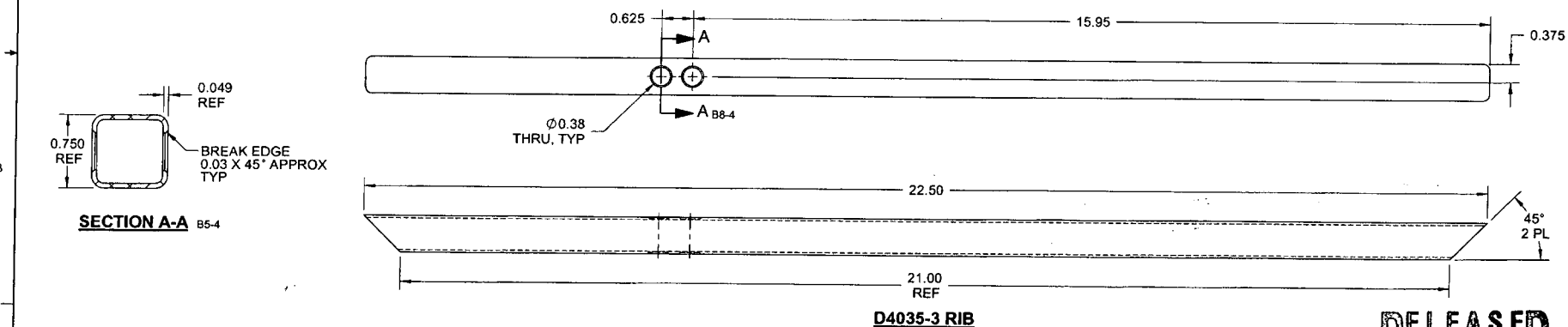
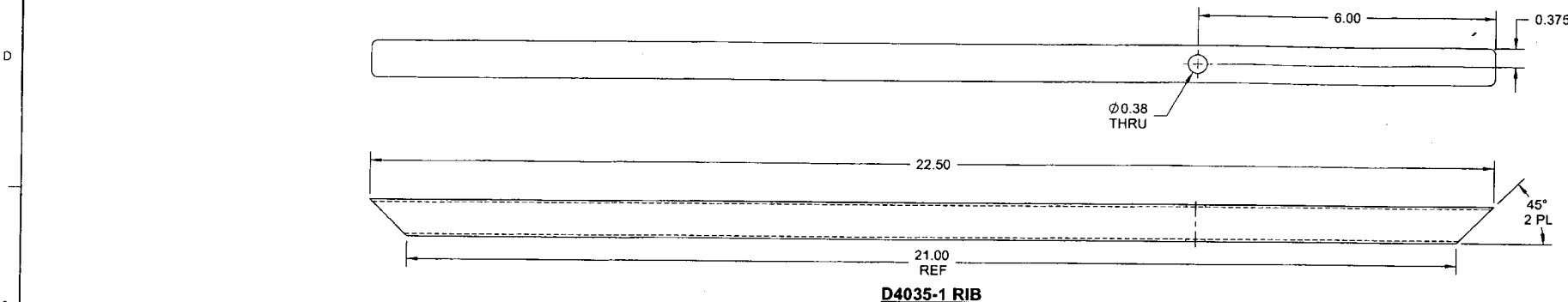
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81201



SECTION A-A 65-4

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.80 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 4 OF 5
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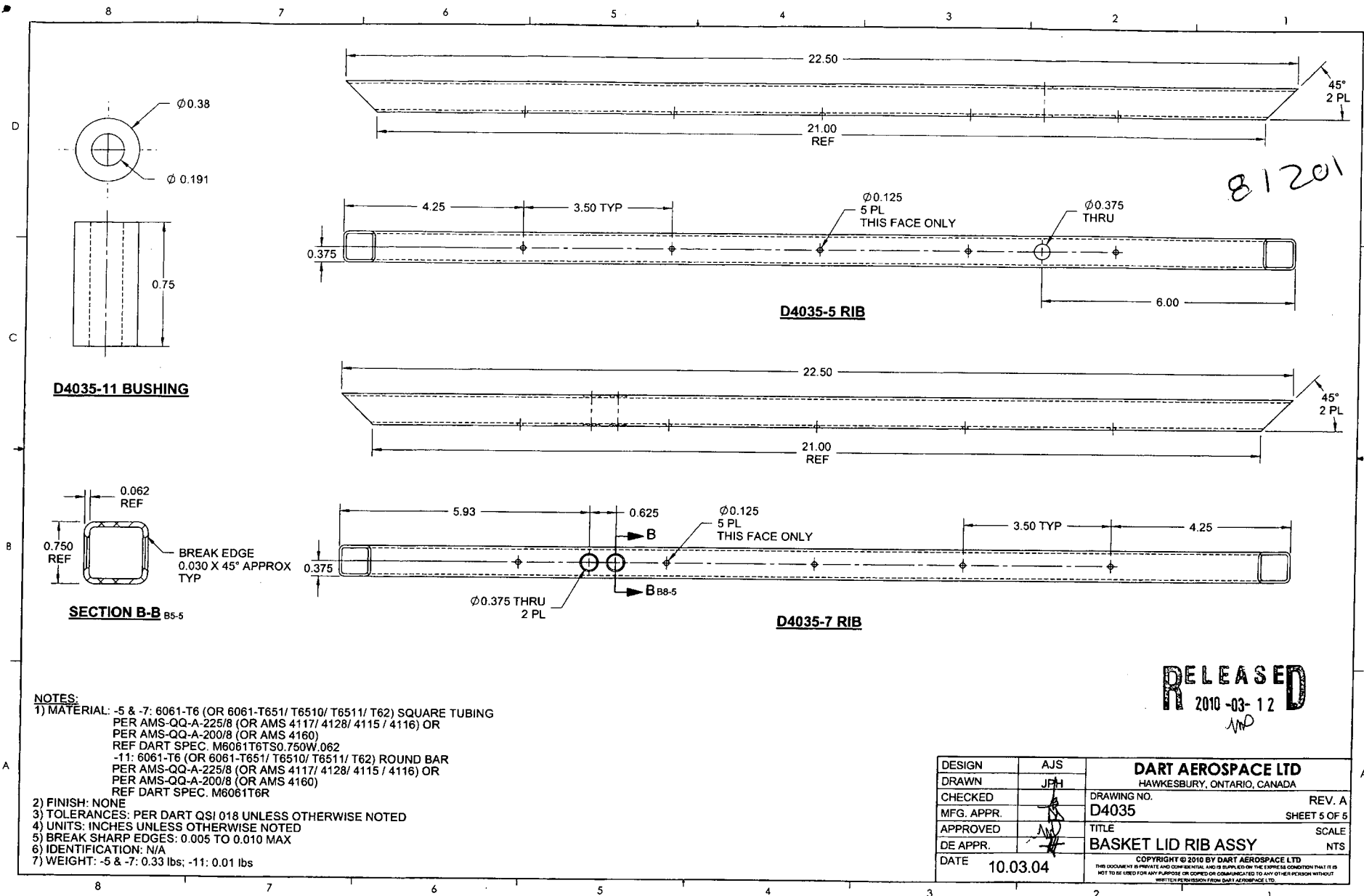
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